

Work Order ID 103665-2

103665

Page 1

June-24-13 2:11:31 PM

Item ID: D4008-041

D 4008-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

B 108885

Stop *NS2*

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 6/24/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/05/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 13-06-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4008

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4008-1)

Dwg Rev: C

Prog Rev: C

6061.032

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

9 0 13.08.12

9 0 13.08.12

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Page 2

Item ID: D4008-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Fuel Filler Splash Guard Assembly

Stop *NS2*

Start Date: 6/24/13 Start Qty: 4.00

4

Required Date: 7/05/13 Req'd Qty: 4.00

4

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

8/2/13

120

QC

0.00

13 8 13

Quality Control

Memo

9

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend D4004-1 as per Dwg

9

13/8/20

140

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9-89

140

QC

0.00

13 8 20

Quality Control

Memo

9

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Item ID: D4008-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fuel Filler Splash Guard Assembly
 Start Date: 6/24/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/05/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

180		0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								

190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

200 → Identify: ST242A

205 → QC 21 - Final Inspection - W/O Close

2X  13-09-20
 /RM 13/09/27
 ~ 1309-24

Picklist Print

June-24-13 2:11:31 PM

Page 1

Work Order ID: 103665

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	679.7000	0.2735	1.1515788	2.6	6/26/13	Ac

Location	Loc Qty	Loc Code
MAT021	679.7	
123135	15	
123137	10	
123293	10	
123483	256.6	
m125822	67.3	
m126115	320.8	

D3941
Rubber Cushion

Manufactured No

180 f 33.9253

0.21 0.8842104

Location	Loc Qty	Loc Code
ST414	33.9252767	
48512	33.9252767	

D4008-5
Fuel Filler Splash Guard Hinge Half

Manufactured No

Each 3.0000

Location	Loc Qty	Loc Code
GA	3	
99188	3	

D4008-9
Spring

Manufactured No

180 Each 11.0000

1 4

Location	Loc Qty	Loc Code
GA	11	
97485	11	

B106510

2x

Picklist Print

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Work Order ID: 103665

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 4.00

Required Qty: 4.00

D4008-7 Washer Manufactured No

180 Each 22.0000 2 8

Location

Loc Qty

Loc Code

GA 1
80629 1
ST083 21
100067 21

180 Each 6,193.0000 5 20

Location

Loc Qty

Loc Code

ST335 6193
1065 1223
16941 4970

MS20470AD3-3 RIVET, UNIVERSAL HEAD

Purchased No

MS21042L08 Nut

Purchased No

Location

Loc Qty

Loc Code

ST315 1691
122141 3
122452 9
122814 500
123900 1179
ST505 2000
125445 2000

180 Each 76.0000 2 8

Location

Loc Qty

Loc Code

ST289 76
122459 76

MS35206-S245 Screw

Purchased No

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Shop Packet Print

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Picklist Print

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Work Order ID: 103665
 Parent Item: D4008-041
 Parent Item Name: Fuel Filler Splash Guard Assembly
 NAS1149DN832J
 Washer

Purchased No

180 Each

1,115.0000

6

24

Start Date: 6/24/13

Required Date: 7/05/13

Start Qty: 4.00

Required Qty: 4.00

Location

Loc Qty

Loc Code

ST293

943

123348

38

123352

103

123603

400

123900

2

124555

400

ST509

172

124093

172

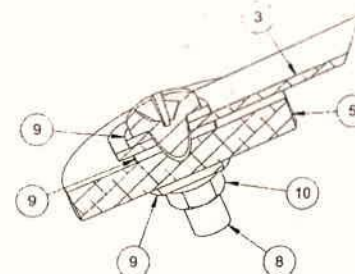
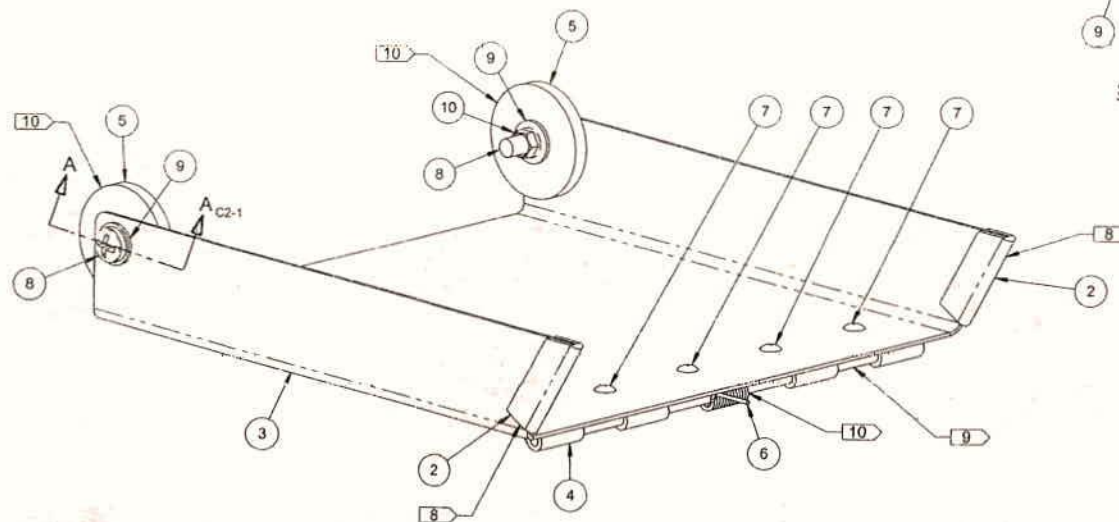
Handwritten: 6/23/28/04
 M126 221 (54K)
Signature

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <i>Al</i>	Audited by: <i>270</i>	Preliminary Approval:
Date: <i>13.08.12</i>	Date: <i>13.8.13</i>	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revE

ITEM NO.	QTY	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



SECTION A-A
SCALE: 2X B6-1
TYP

D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

C	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", CORRECT MATERIAL ERROR, ZN A7-6, ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.01.17		

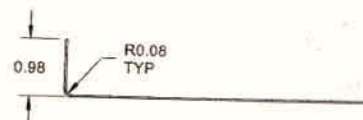
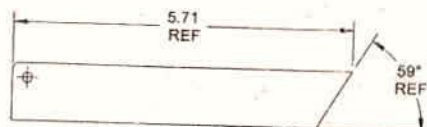
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4008	REV. C
TITLE SPLASH GUARD	SHEET 1 OF 10
SCALE NTS	NTS
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103665 MLC
13-06-25

103663

DART AEROSPACE
PART NUMBER
D4008-1

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-26



D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

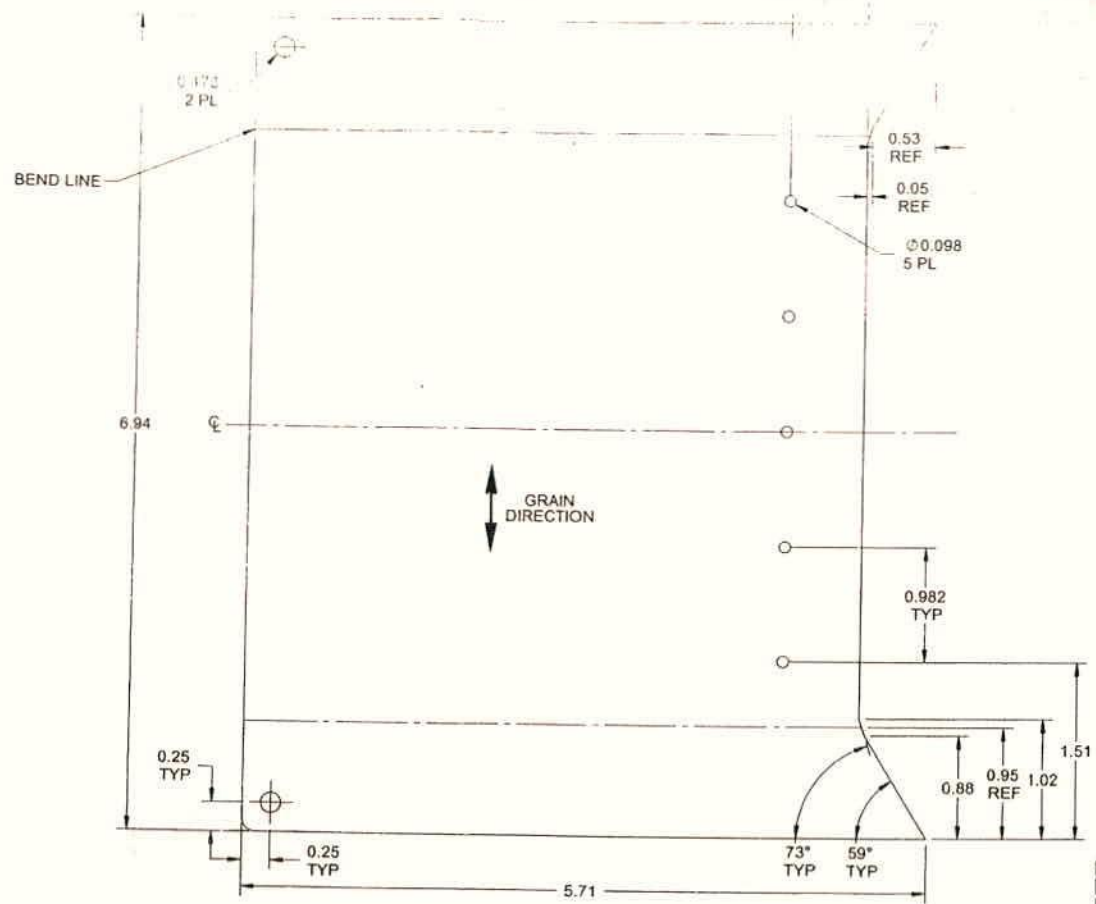
2012-03-02

NOTES:

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4008	SHEET 3 OF 10
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
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105643



D4008-1F FLAT PATTERN

RELEASED
14 2012-03-02
WJ

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

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